

17/9

Dart Aerospace Ltd.

Date: Tuesday, 9/11/2007 10:55:59 AM
 User: Chantal Lavoie

Process Sheet

Customer :	Drawing Name : STIFFNER
Job Number : 34541	
Estimate Number : 12958	
P.O. Number : N/A	Part Number : D36394
This Issue : 9/11/2007	S.O. No. : N/A
Prsht Rev. : NC	Drawing Number : D3639 UNDER REVIEW
First Issue : N/A	Project Number : N/A
Previous Run : N/A	Drawing Revision : U/R
Written By :	Material : N/A
Checked & Approved By :	Due Date : 9/18/2007
Comment : Est Rev A New Issue 07-07-20 JLM	Qty: 10 Um: Each
Verified By: EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M2024T3S050	2024-T3 .050 sheet
		 Comment: Qty.: 0.4491 sf(s)/Unit Total: 4.4909 sf(s) 2024-T3 .050 sheet Batch: M 105646 1B07-09-19
2.0	WATER JET	FLOW WATER JET
		 Comment: FLOW WATER JET 1-Cut as per Dwg D3639 Dwg Rev: PRE L 1B07-09-19 Prog Rev: PRE L 2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 Comment: INSPECT PARTS AS THEY COME OFF MACHINE AB 07-09-19
4.0	QC8	SECOND CHECK
		 Comment: SECOND CHECK CR 109/19 XCO
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 Comment: SMALL & MEDIUM FAB RESOURCE 1 C'sink as per Dwg D3639 N/A 107-09-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/01/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
01/09/12	# 20	5 parts scrap. wrong Program was used (Preliminary not the new DFT) causing the location of the 0.625" and 0.191 holes	Initial Fosiarz	Scrap and Destroy and Replace all parts	01/09/12 Fosiarz	En 01/09/12	/	En 01/09/12
		To be off by 0.100" R.C. wrong program was on the network and Human operator error. (written 3x)	Initial Fosiarz	Remove wrong program from the network	01/09/12 Fosiarz	En 01/09/12	/	En 01/09/12

NOTE: Date & initial all entries

Date: Tuesday, 9/11/2007 10:56:00 AM
User: Chantal Lavoie

Process Sheet

Customer:		Drawing Name: STIFFNER
Job Number: 34541		Part Number: D36394
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Form as per Dwg D3639		SB 07/09/20 10
7.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		En 07/09/20 10
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		FL 07/09/20 10
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		En 07/09/20 10 cauto
10.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify with P/N and B/N using a permanent fine point marker, then Stock Location: _____ 11/10/15 50		UE 07.10.14 10x ENGINEERING APPROVAL 10
11.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		10 D 07/10/2022
Job Completion 		
<p>POSITIVE RECALL EFFECTIVE 07.09.11 RELEASED 10 AUTH DATE 07.10.14</p> <p>10 8.10.16</p>		

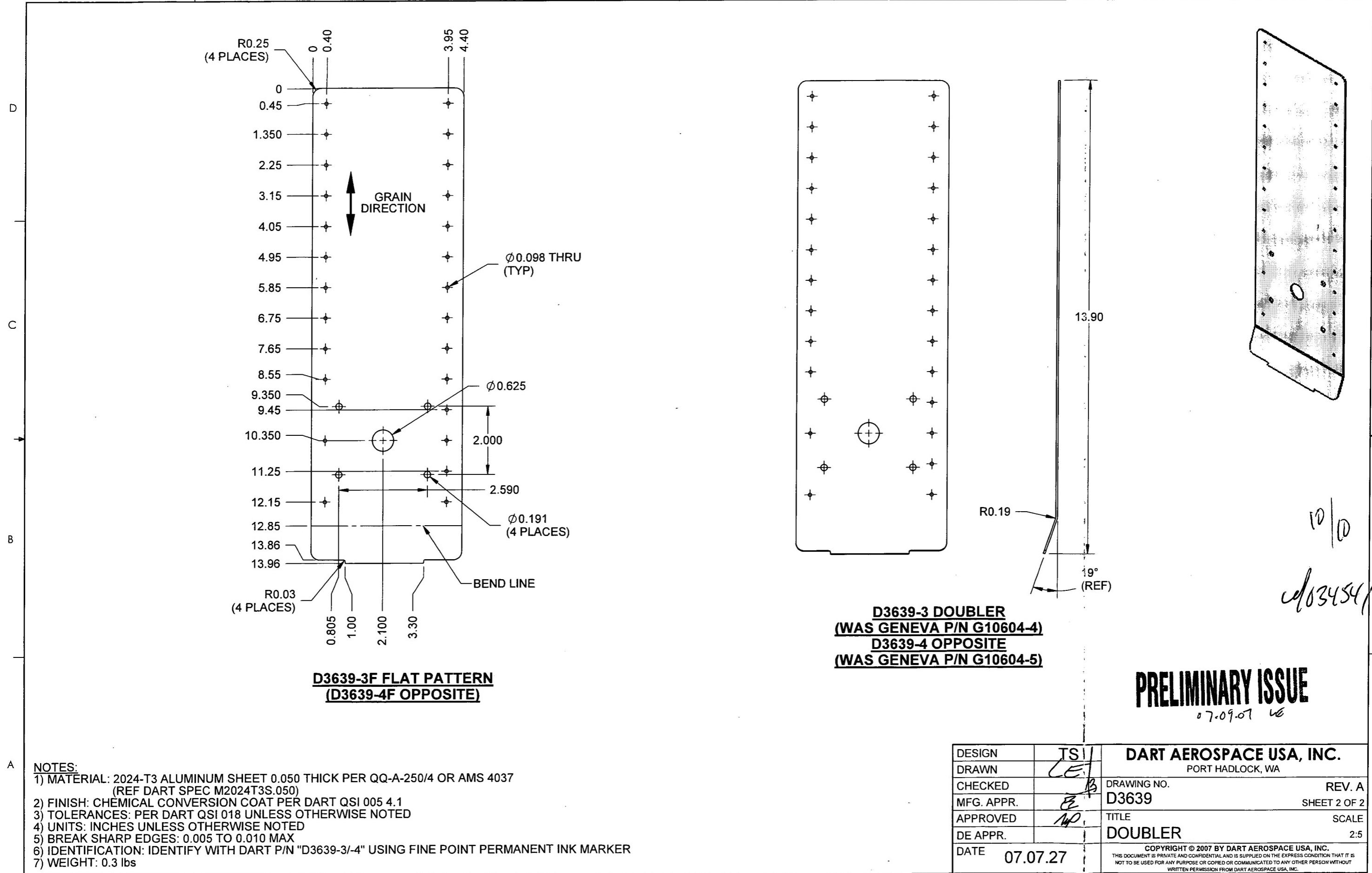
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



DART AEROSPACE LTD	Work Order:	34541
Description: STIFFENER	Part Number:	D3681-4
Inspection Dwg:	Rev: P.R.E.L	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
$\phi .098$	$+.004 - .001$.100	X			
$\phi .191$	$+.005 - .001$.194	X			
$\phi .625$	$+.008 - .001$.627	X			
.45	$+.030$.45	X			
1.350	$+.010$	1.350	X			
2.25	$+.030$	2.25	X			
3.15	$+.030$	3.15	X			
4.05	$+.030$	4.05	X			
4.95	$+.030$	4.94	X			
5.85	$+.030$	5.85	X			
6.75	$+.030$	6.75	/			
7.65	$+.030$	7.65	/			
8.55	$+.030$	8.55	/			
9.350	$+.010$	9.350	/			
9.45	$+.030$	9.45	/			
10.350	$+.010$	10.350	/			
11.25	$+.030$	11.25	/			
12.15	$+.030$	12.15	X			
12.85	$+.020$	BEND LINE				
13.86	$+.030$	13.86	X			
13.96	$+.030$	13.96	X			
14.65	$+.010$					
14.60	$+.009$					

continued on next Page

Measured by:	Audited by:	Prototype Approval:
Date: 07-09-19	Date: 07-09-19	Date: 07.09.19

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order:	34541
Description: ST: F4U-2	Part Number:	D 3639-4
Inspection Dwg: Rev: P26L		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>LB</u>	Audited by:	<u>EN</u>	Prototype Approval:	<u>LG</u>
Date:	07-09-19	Date:	07-09-19	Date:	07.09.19

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	